

Styles 22, 31, 41 & 44 Couplings for Vic-Ring® Adapter and Shouldered End Pipe

ASSEMBLY



The following step-by-step procedures are designed as a guide for proper assembly of Victaulic couplings on Vic-Ring® or shouldered end pipe.

Vic-Ring and shouldered end pipe must be properly dimensioned in accordance with the latest Victaulic specifications for size and style of coupling being utilized.

ALWAYS CHECK GASKET SUPPLIED TO BE CERTAIN IT IS SUITED FOR THE INTENDED SERVICE.

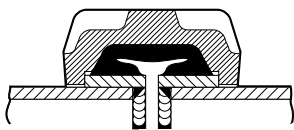
Styles 22, 41 & 44 couplings are supplied with Victaulic Grade “E” or “T” gaskets which are specially designed for water or oil services, respectively. Style 31 couplings are supplied with Victaulic Grades “M” and “S” FlushSeal gaskets which are specially designed for water or oil services, respectively.

Maximum service life is dependent upon proper gasket selection and installation. Be sure to note gasket grade being supplied and make certain that it is suited for the intended service. The chart on page 2 provides general service recommendations for standard Victaulic gaskets. For more detailed information, consult the Victaulic Gasket Selection Guide or call Victaulic.

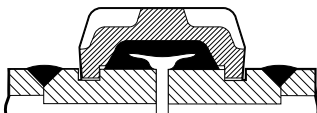
Vic-Ring Installation

The fabricator/welder bears the full responsibility of ensuring that a quality weld capable of withstanding all thrust loads is made in accordance with appropriate American Welding Society (AWS) specifications and that applicable safety procedures are followed.

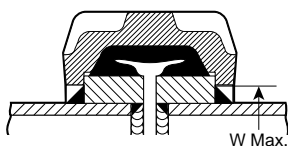
NOTE: All welds must be leak tight.



Type A Vic-Ring Adapter

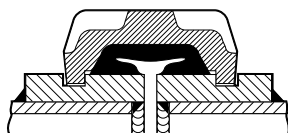


Type B Vic-Ring Adapter

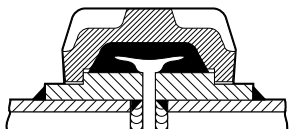


Type C Vic-Ring Adapter

NOTE: “W Max.” dimension can be found in chart at right.



Type D Vic-Ring Adapter



Type E Vic-Ring Adapter

**MAXIMUM WELD O.D.
TYPE “C” VIC-RING**

Coupling Data			Coupling Data		
Size Inches	Style	W Max. +0”/-0.06” Inches	Size Inches	Style	W Max. +0”/-0.06” Inches
mm		mm	mm		mm
14	31	14.97	42	41	44.81
350		380.2	1050		1138.2
16	44	18.00	42	44	45.81
400		457.2	1050		1163.6
18	31	19.09	46	41	47.88
450		484.9	1175		1216.2
20	31	21.19	48	41	51.03
500		538.2	1225		1296.2
24	31	25.38	48	44	52.19
600		644.7	1225		1325.6
30	41	32.31	54	41	57.44
750		820.7	1375		1459.0
30	44	33.00	54	44	58.63
750		838.2	1375		1489.2
36	41	38.97	60	41	63.63
900		989.8	1500		1616.2
36	44	39.44	60	44	65.06
900		1001.8	1500		1652.5
38	41	40.13	66	41	69.63
975		1019.3	1675		1768.6

These Vic-Ring adapters are not to be considered as pipe reinforcement. If reinforcement is required, provision must be made by the designer.

For other ring specifications request 16.06.

Installation and Assembly

Grade	Temp. Range	Compound	Color Code	General Service Recommendations
E	-30°F to +230°F	EPDM	Green Stripe	Recommended for hot water service within the specified temperature range plus a variety of dilute acids, oil-free air and many chemical services. NOT RECOMMENDED FOR PETROLEUM SERVICES.
T	-20°F to +180°F	Nitrile	Orange Stripe	Recommended for petroleum products, hydrocarbons, air with oil vapors, vegetable and mineral oils within the specified temperature range; except hot dry air over +140°F (+66°C) and water over +150°F (+66°C). NOT RECOMMENDED FOR HOT WATER SERVICES.

FOR STYLE 31 COUPLING ONLY

M	-20°F to +200°F	Halogenated Butyl	Brown Stripe	Specially compounded to conform to ductile pipe surfaces. Recommended for water service within the specified temperature range plus a variety of dilute acids, oil-free air and many chemical services. NOT RECOMMENDED FOR PETROLEUM SERVICES.
S	-20°F to +180°F	Nitrile	Red Stripe	Specially compounded to conform to ductile pipe surfaces. Recommended for petroleum products, air with oil vapors, vegetable and mineral oils within the specified temperature range; except hot dry air over +140°F and water over +150°F. NOT RECOMMENDED FOR HOT WATER SERVICES.

*Refer to VICTAULIC GASKET SELECTION GUIDE for specific service recommendations.

Services listed are Gasket Service Recommendations only. It should be noted that there are services for which these gaskets are **not** recommended. Reference should always be made to the latest Victaulic Gasket Selection Guide for specific gasket service recommendations and for a listing of services which are not recommended.

ALWAYS SPECIFY THE PROPER GASKET GRADE TO ASSURE MAXIMUM SERVICE LIFE FOR THE INTENDED APPLICATION.

Pipe Preparation

Vic-Ring or shoulder must be checked to be sure it is sufficiently free from loose coatings, mill scale, rust, indentations or projections on the gasket sealing surface, to assure a leak-tight seat for the gasket. Vic-Ring ends should be square to the pipe centerline.

ALWAYS USE LUBRICATION FOR PROPER GASKET ASSEMBLY.

Thorough lubrication of the gasket exterior including the lips and/or Vic-Ring ends is essential to prevent pinching the gasket. Lubrication assists proper gasket seating and alignment while easing installation.

Use VICTAULIC LUBRICANT for installation. Other compatible lubricants such as silicone and others may be used, however, **petroleum based lubricants must not be used on Grades “E” and “M” gaskets.**

ASSEMBLY

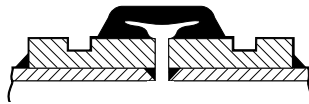
1. CHECK PIPE ENDS: Installed Vic-Ring adapter or shouldered ends must be free from loose coatings, mill scale, rust, indentations or projections on exterior along the gasket seat, to assure a leak-tight seal for the gasket.



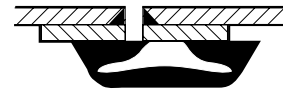
2. CHECK GASKET AND LUBRICATE: Check gasket supplied to be certain it is suited for intended service. Color code identifies gasket grade. Apply a thin coat of Victaulic lubricant or silicone lubricant to gasket lips and outside of gasket.



3. INSTALL GASKET: Place gasket over Vic-Ring adapter, being sure gasket lip does not overhang seating area. To ease gasket installation, the gasket may be rolled over the Vic-Rings such that the sealing lips are on the outside of the gasket.



4. JOIN PIPE ENDS: Align and bring two pipe ends together and slide (or roll) the gasket into position centered between both the Vic-Ring grooves or shouldered ends.



INCORRECT
GASKET POSITION

The above illustrates an example of **IMPROPER** positioning of the gasket. The gasket sealing lips should be in firm contact with the Vic-Ring adapter surface. No portion of the gasket should extend beyond the gasket sealing surface or into the grooves.

NOTE: If visual confirmation cannot be made 360° around the gasket, use hand to confirm gasket is properly seated on the Vic-Ring/shoulder sealing surfaces.



5. APPLY HOUSING: Place housings over gasket, being sure the housing keys engage into the grooves or over shoulders. To ease installation, first preassemble the segments loosely into pairs, allowing slight clearance between segments. Install "pairs" over the gasket, again checking that the housing keys engage into the grooves. As the coupling "pairs" are put in place, insert the bolts and apply the nuts finger-tight.



6. TIGHTEN NUTS: Tighten nuts alternately and equally until housing bolt pads are firmly together — metal-to-metal. Be sure coupling fully engages in grooves when tightening.

WARNING

Piping systems must always be depressurized and drained before attempting disassembly and removal of any Victaulic piping products or installation or removal of valve.

Failure to do so could result in serious personal injury, property damage, joint leakage or joint separation.